

Rush

Work Order ID 63245



Page 1

Tuesday, October 26, 2010 10:17:03 AM

Item ID:	D3201-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	10/26/2010	Start Qty:	20.00			
Required Date:	10/29/2010	Req'd Qty:	20.00			
Reference:						

Approvals:	Process Plan:	<i>JP</i>	Date:	<i>10-10-26</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3201	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet									
FLOW CNC Waterjet	Memo	0.00							
<i>2024 .050</i>	1-Cut as per Dwg D3201 <input type="checkbox"/> Dwg Rev: <i>B</i> <input type="checkbox"/> Prog Rev: <i>B</i> <input type="checkbox"/> 2- Deburr if necessary								

B10-10-26

510/10/26

(24)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

B10-10-26

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

510/10/26

Waters
(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63245

Tuesday, October 26, 2010 10:17:03 AM

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Item ID: D3201-3

Accept

Setup Start

Revision ID:

Item Name: Doubler

Stop

Start Date: 10/26/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr Stack

GP 10/10/26 (24)

140

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Bend as per Dwg D3201 ☐ 2-Scribe part# and Batch# per dwg D3201

SD 10/10/27

(24)

n/a

PR →

150

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SD 10/10/27

(24-3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<i>Perm. Change</i>					
10/10/26	# 100	Remove to describe part.					<i>S</i> 10/10/26

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 63245

Tuesday, October 26, 2010 10:17:03 AM



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Item ID: D3201-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 10/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		10/10/27		24	0		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				24		62	10-10-27
180 Packaging Packaging	Identify as per dwg & Stock Location: 41 Memo	0.00 0.00				10/10/27		24	

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D3201-3

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Setup Start

Revision ID:

Stop

Item Name: Doubler

Start Date: 10/26/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29 *[Signature]*

10-10-28

(24)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 10:17:07 AM

Page 1

Work Order ID: 63245



Parent Item: D3201-3



Parent Item Name: Doubler

Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A Removed from 9 Digit 06-01-25 JLM
 IPP Rev:B Now on Waterjet 06-08-14 JLM
 IPP Rev C added scribing NCR262 07.11.29 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	106.8847	0.045	0.947368			



2024-T3 .050 sheet



B 10-10-24

Location

Loc Qty

Loc Code

MAT22

106.8847

111381

11.89

113189

0.3947

114968

94.6

114 968

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Dart Aerospace Ltd

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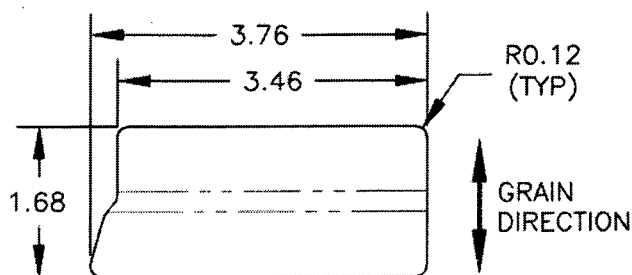
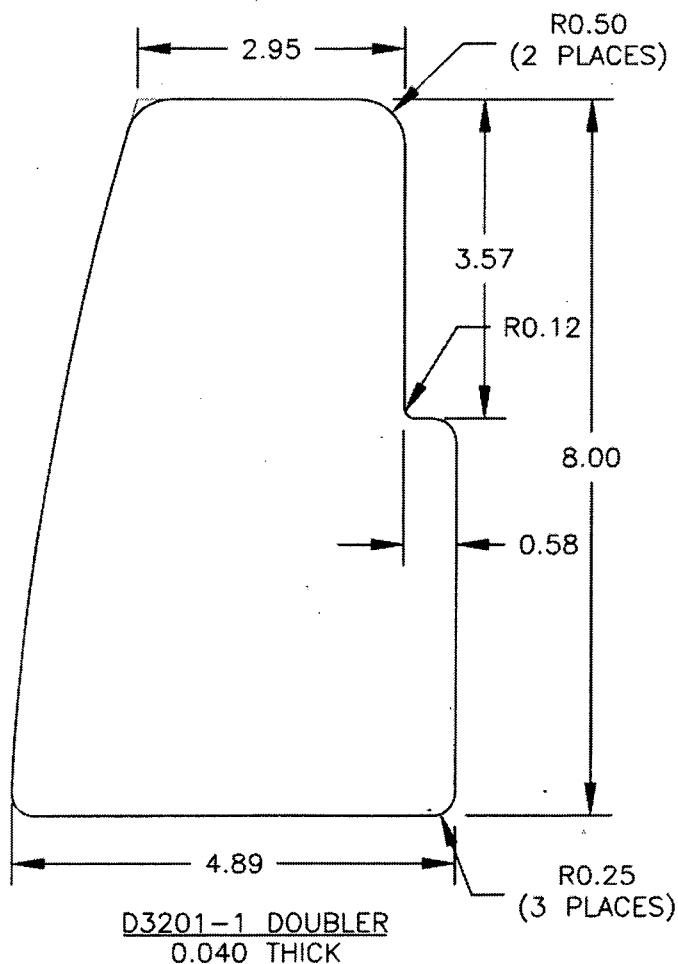
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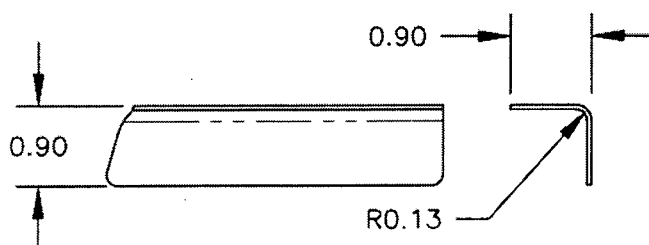


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03	TITLE DOUBLER		SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14



D3201-3/-4 ANGLE
(FLAT PATTERN)



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK

D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63245

21101026

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